

# Work Order ID 59816

Friday, June 11, 2010 10:48:25 AM



Page 1

Item ID: D117-762-041

Accept



Setup

Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 6/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date:

*6/10/11*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001 *N/A*

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr  
2-Drill #30 pilot holes using DT8678.  
3- open holes to 5/16"

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend tube as per program D3582 on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A". use bending aid DT4632  
2-cut Free end of tube as per dwg

*10.06.14*

*DP*

*10-6-14*

*DP*

*10-6-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

~~1-Cut Fwd end of the tube using DT8185~~

2-Cut Aft end using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 \*\*\*DO NOT OPEN AFT CAP HOLE\*\*\*

5-Locate DT 8973 &amp; Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

DP 10-6-14

AWM 10-06-24

DP 10-6-28

DP 10-6-28

W/O:		WORK ORDER CHANGES					
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Item Name: Replacement Skidtube

Start Date: 6/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld fwd cap D2964 per dwg D3582 and QSI004 A/R AL ROD Batch: <u>M114242</u> 2-Grind flush <u>H 06/29</u>								<u>BE 10/06/28</u>
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							<u>810/06/09</u>
160  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							<u>810/09/09</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 11/06/29

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

21

BF 10/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 &amp; QSI 015

A/R 241 Sike Flex Batch: M113519  
Exp Date: 10/11/30

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M114242

6-Grind welds flush

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

200



QC

Quality Control

8/10/06/30

M 10/6/29

BE 10/06/30

BE 10/06/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



8.1066130

QC

Memo

0.00

Quality Control

215

Pressure Wash per QSI005 4.3

0.00



0.00

HandFinish

Memo

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



0.00

Powdercoat

Memo

Powder Coating

START TIME

OVEN TEMPERATURE:

FINISH TIME:

M4841  
9:20  
320°  
9:50

1

1 BL 10-7-1

1 BL 10-7-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 59816**

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Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC3- Inspect Part Finish

0.00

=&gt; 41 10107105



QC

Memo

0.00

Quality Control

1

0

240

HandFinishing

0.00

=&gt; 41 10107105



HandFinish

Memo

0.00

Hand Finishing

Install Wearplate &amp; Ground Wire inserts as per Dwg D3582.

1

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 6/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  HandFinish Hand Finishing	HandFinishing  Memo 1-Inspect for Foreign objects  2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: <u>M113519</u> Exp Date: <u>10/11</u>  3-Install Wearplates as per Dwg D3582, Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** A/R 241 Sika Flex Batch: <u>M113519</u> Exp Date: <u>10/11</u>  4-assemble o'ring as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M114189</u>  5- Wing Walk as per Dwg D3043 and QSI 005 4.4 <u>M114432</u>	0.00  0.00		<u>10107105</u>		<u>XL</u>	<u>0</u>		
260  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<u>8 10107105</u>		<u>(X)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D117-762-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_ *PIP 59757*

280

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*Rec'd 6/16/10**100707**MF 10-7-6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, June 11, 2010 10:48:29 AM

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube






Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC  
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150  3.540 Outer Tube, Extrut		Manufactured	No			110	Each	31.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		31							
				28672		31							
D2964  Cap		Manufactured	No			140	Each	23.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		23							
				14101		23							
D2971  Cross Bolt Spacer		Manufactured	No			190	Each	31.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		31							
				44445		31							
D3584-1  Web		Manufactured	No			190	Each	0.0000	1	1			
D2973  Cross Bolt Spacer		Manufactured	No			190	Each	180.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		180							
				14636		180							



10-6-14

1

BE 10/06/28

1

BE 10/06/30

359785  
BNA 10/6/29 H

2

BE 10/06/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 6/11/2010




Required Date: 6/18/2010

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																												
D3662-3  Crossbolt Spacer		Manufactured	No			190	Each	29.0000	1	1																															
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>LG</td><td>29</td><td></td></tr><tr><td>44456</td><td>29</td><td></td></tr></table>														Location	Loc Qty	Loc Code	LG	29		44456	29																				
Location	Loc Qty	Loc Code																																							
LG	29																																								
44456	29																																								
D3662-1  Crossbolt Spacer		Manufactured	No			190	Each	25.0000	3	3		BE 10/06/30																													
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>LG</td><td>25</td><td></td></tr><tr><td>39585</td><td>5</td><td></td></tr><tr><td>55328</td><td>20</td><td></td></tr></table>														Location	Loc Qty	Loc Code	LG	25		39585	5		55328	20																	
Location	Loc Qty	Loc Code																																							
LG	25																																								
39585	5																																								
55328	20																																								
ALS4-1032-130  Insert		Purchased	No			240	Each	5,752.000	36	36		BE 10/06/30																													
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>PKG11</td><td>5000</td><td></td></tr><tr><td>114723</td><td>5000</td><td></td></tr><tr><td>ST282</td><td>305</td><td></td></tr><tr><td>110511</td><td>38</td><td></td></tr><tr><td>114407</td><td>267</td><td></td></tr><tr><td>ST381</td><td>447</td><td></td></tr><tr><td>114654</td><td>447</td><td></td></tr></table>														Location	Loc Qty	Loc Code	PKG11	5000		114723	5000		ST282	305		110511	38		114407	267		ST381	447		114654	447					
Location	Loc Qty	Loc Code																																							
PKG11	5000																																								
114723	5000																																								
ST282	305																																								
110511	38																																								
114407	267																																								
ST381	447																																								
114654	447																																								
<table><tr><td>x36</td><td>MS</td><td>10/07/05</td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td></tr></table>														x36	MS	10/07/05																									
x36	MS	10/07/05																																							

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC  
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-428-165		Purchased	No			240	Each	143.0000	2	2			
Inserts													

Location	Loc Qty	Loc Code
FP	43	
6989	43	
ST282	100	
114172	100	
D2965	250	Each
Manufactured	No	49.0000
Cap, 105 Skidtube		

Location	Loc Qty	Loc Code
FP4	49	
2057	48	
59600	1	
D3508-3	250	Each
Manufactured	No	7.0000
Wearplate		

Location	Loc Qty	Loc Code
FP21	7	
51386	1	
55339	6	
D3508-9	250	Each
Manufactured	No	8.0000
Wearplate		

Location	Loc Qty	Loc Code
FP21	8	
54580	8	

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC





IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																								
D3558-3  Gasket		Manufactured	No			250	Each	18.0000	1	1																																																											
<table border="0"> <tr> <td></td><td><u>Location</u></td><td></td><td></td><td></td><td></td><td><u>Loc Qty</u></td><td></td><td><u>Loc Code</u></td><td colspan="5"></td></tr> <tr> <td></td><td>FP</td><td></td><td></td><td></td><td></td><td>18</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>(5139)</td><td>6</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>55468</td><td>12</td><td></td><td></td><td colspan="5"></td></tr> </table>															<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>							FP					18													(5139)	6													55468	12							
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	FP					18																																																															
					(5139)	6																																																															
					55468	12																																																															
D3558-9  Gasket		Manufactured	No			250	Each	23.0000	1	1																																																											
<table border="0"> <tr> <td></td><td><u>Location</u></td><td></td><td></td><td></td><td></td><td><u>Loc Qty</u></td><td></td><td><u>Loc Code</u></td><td colspan="5"></td></tr> <tr> <td></td><td>FP</td><td></td><td></td><td></td><td></td><td>23</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>(50928)</td><td>9</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>55469</td><td>14</td><td></td><td></td><td colspan="5"></td></tr> </table>															<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>							FP					23													(50928)	9													55469	14							
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	FP					23																																																															
					(50928)	9																																																															
					55469	14																																																															
D3558-11  Gasket		Manufactured	No			250	Each	7.0000	1	1																																																											
<table border="0"> <tr> <td></td><td><u>Location</u></td><td></td><td></td><td></td><td></td><td><u>Loc Qty</u></td><td></td><td><u>Loc Code</u></td><td colspan="5"></td></tr> <tr> <td></td><td>FP</td><td></td><td></td><td></td><td></td><td>7</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>(42254)</td><td>7</td><td></td><td></td><td colspan="5"></td></tr> </table>															<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>							FP					7													(42254)	7																					
	<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>																																																													
	FP					7																																																															
					(42254)	7																																																															
D3558-13  Gasket		Manufactured	No			250	Each	4.0000	1	1																																																											
<table border="0"> <tr> <td></td><td><u>Location</u></td><td></td><td></td><td></td><td></td><td><u>Loc Qty</u></td><td></td><td><u>Loc Code</u></td><td colspan="5"></td></tr> <tr> <td></td><td>FP</td><td></td><td></td><td></td><td></td><td>4</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>(42255)</td><td>2</td><td></td><td></td><td colspan="5"></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td><td>55467</td><td>2</td><td></td><td></td><td colspan="5"></td></tr> </table>															<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>							FP					4													(42255)	2													55467	2							
	<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>																																																													
	FP					4																																																															
					(42255)	2																																																															
					55467	2																																																															

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/11/2010

Required Date: 6/18/2010

Comments: IPP Rev:A 07.06.11 New Issue EC

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3508-11 Wearplate		Manufactured	No			250	Each	15.0000	1	1			
<div> <div>Location</div> <div>FP16</div> <div>54644</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div>B46880</div> </div>													
D3508-13 Wearplate		Manufactured	No			250	Each	14.0000	1	1			
<div> <div>Location</div> <div>FP</div> <div>54645</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>14</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3492-051 Plug Assembly		Manufactured	No			250	Each	58.0000	2	2			
<div> <div>Location</div> <div>FP013</div> <div>44633</div> <div>55622</div> </div> <div> <div>Loc Qty</div> <div>58</div> <div>8</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3492-049 Plug Assembly		Manufactured	No			250	Each	33.0000	2	2			
<div> <div>Location</div> <div>FP011</div> <div>44632</div> <div>55621</div> </div> <div> <div>Loc Qty</div> <div>33</div> <div>3</div> <div>30</div> </div> <div> <div>Loc Code</div> <div></div> </div>													

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:A 07.06.11 New Issue EC

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 1.00

Required Qty: 1:00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-053		Manufactured	No			250	Each	31.0000	6	6			
Plug Assembly													

## Location

## Loc Qty

## Loc Code

FP

31

31

250

Each

3,779.000

2

2

Y6 10/07/05

AN960JD10L

NAS1149D0332J

Purchased

No



Washer

## Location

## Loc Qty

## Loc Code

ST348

3779

3779

250

Each

1,525.000

28

28

Y2 10/07/05

AN3C4A

Purchased

No



BOLT

## Location

## Loc Qty

## Loc Code

ST350

1525

114103

501

114108

14

114416

12

114523

2

114859

996

Y2 10/09/05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC


IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010


Required Date: 6/18/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C5A		Purchased	No			250	Each	352.0000	2	2			
													
Bolt													

Location	Loc Qty	Loc Code
ST350	337	
114330	11	
114523	18	
114808	308	
ST351	15	
113121	10	
114108	5	

AN960JD416L	NAS1149D0416J	Purchased	No			250	Each	371.0000	2	2			
													
Washer													

Location	Loc Qty	Loc Code
ST346	371	
110153	371	

AN960C10L	NAS1149C0332	Purchased	No			250	Each	0.0000	28	28			
													
washer													

X2 10/07/05

X2 10/07/05

X28 10/07/05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 59816

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:A ☐ 07.06.11 ☐ New Issue ☐ EC


IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			250	Each	224.0000	2	2			
													
Bolt													

Location Loc Qty Loc Code

ST356 200

114615 200

ST361 24

108138 6

111295 18

NAS1611-012

Purchased

No

250

Each

122.0000

6

6

O-RING

Location Loc Qty Loc Code

FP 122

10867 21

113845 101

NAS1611-015

Purchased

No

250

Each

9.0000

2

2

O-RING

Location Loc Qty Loc Code

FP 9

107178 9

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x2 M 10/07/05

x6 M 10/07/05

x2 M 10/07/05

x2 M 10/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 59816



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 6/11/2010

Required Date: 6/18/2010

Comments: IPP Rev:A 07.06.11 New Issue EC

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1611-016		Purchased	No			250	Each	113.0000	2	2			



O-RING



Location

Loc Qty

Loc Code

FP

113

107178

13

112492

50

113524

50

x2 10107105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

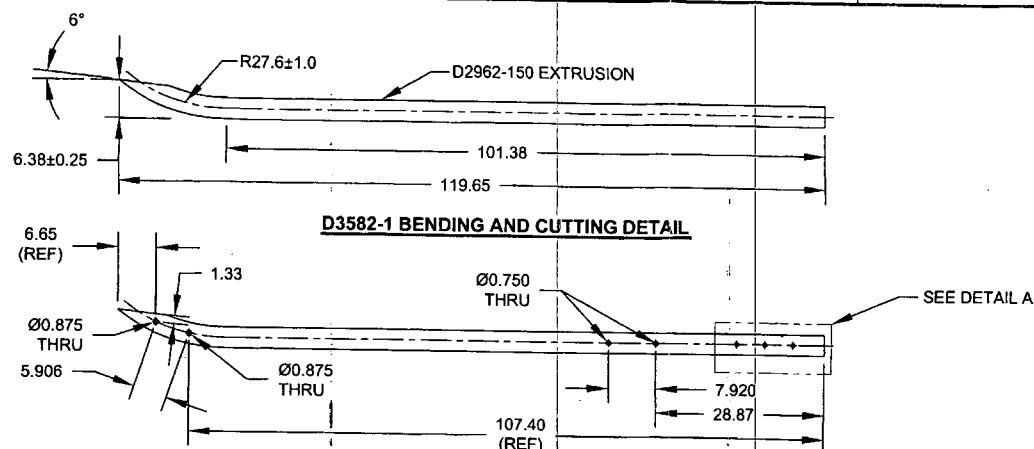
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

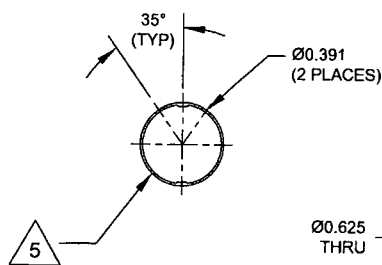
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-055	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELDING TO BE DONE PER DART QSI 004.
- 4) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241I-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 5) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241I-291.
- 6) DO NOT INSTALL AN3C4A BOLTS AND AN960C1QL WASHERS IN INDICATED LOCATIONS.
- 7) FINISH:
  - A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
  - B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
  - C) ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.



Technical drawing of a rectangular plate with the following dimensions and features:

- Overall width: 15.08
- Distance from left edge to first hole center: 9.646
- Distance between first and second hole centers: 4.843
- Distance from second hole center to right edge: 0.40
- Overall height: 7.31
- Distance from bottom edge to hole centers: B
- Distance from right edge to hole centers: B
- Hole diameter:  $\varnothing 0.625$  THRU
- Dimension lines are shown with arrows and numerical values.



**DETAIL A**  
**SCALE 1:5**

**DEO ATTACHED**

RELEASE  
07.11.22

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 59816

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3582	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	BK 117 SKIDTUBE ASSEMBLY	1:2
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY OTHER MANNER WITHOUT A WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

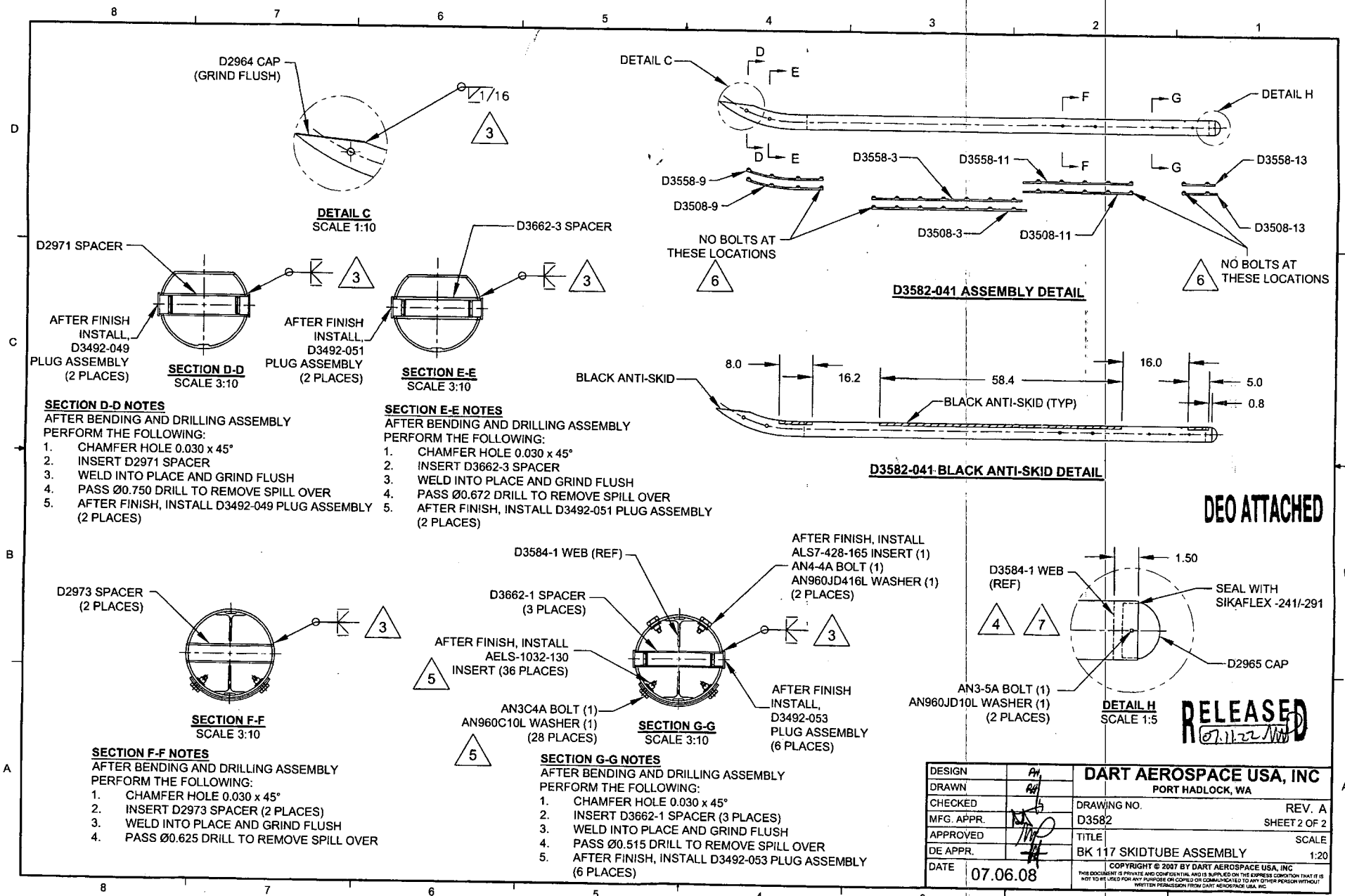
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



WLO 59814

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

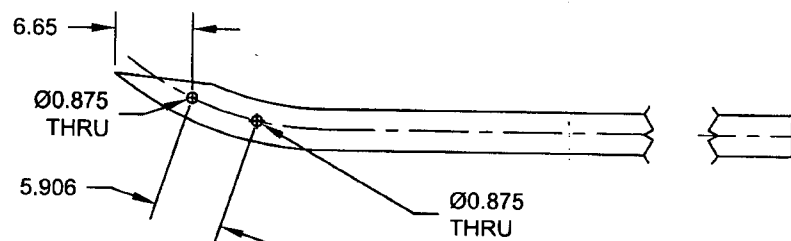
NOTE: Date & initial all entries



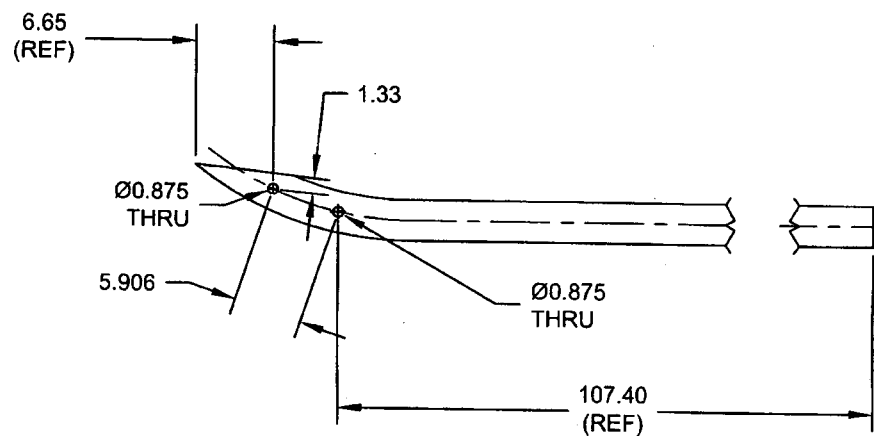
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:  
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



**RELEASED**  
09/04/22 *[Signature]*

*WU 59816*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 220

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Bardlay Elliott  
Job number: 54161  
Part number: D17-762-041  
Description: 17 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier B.D. Date of Test Coupon 09/12/10

Welder Bardlay Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld